

Claims

- [c1] A method of replacing an abradable portion on the casing of a turbojet fan, the turbojet having a rotary portion, the rotary portion comprising a shaft having a fan stage attached to its front end, the fan stage comprising a hub supporting a plurality of blades, the turbojet also comprising an annular fan casing surrounding the fan stage, said fan casing comprising an inside wall against which a likewise annular abradable portion is bonded, the bonding surfaces of the abradable portion and of the fan casing, the surface of the abradable portion opposite from its bonding surface being referred to as its "sealing" surface, the fan casing having a plurality of fixing points, the fan stage having previously been removed, the method comprising:
- a) removing the worn abradable portion;
 - b) preparing a new abradable portion;
 - c) applying adhesive to the bonding surfaces of the abradable portion and of the fan casing, said bonding surfaces having previously been cleaned;
 - d) applying the abradable portion against the inside wall of the fan casing;
 - e) putting an "inside" heating belt into place against the

sealing surface of the abradable portion, the inside heating belt completely covering the abradable portion;

f) putting holding sectors into place against the inside heating belt, each holding sector including an inflatable bladder, the abradable portion and the inside heating belt being sandwiched in full between the fan casing and the bladders, the holding sectors themselves being held in place by a plurality of straps attached to the fan casing by the fixing pints;

g) connecting the bladders to a common source of air under pressure and connecting the inside heating belt to a regulated electrical power supply, pressurizing the bladders, and heating the adhesive in application of a cycle of temperature and pressure conditions that is adapted to the adhesive used and to the thermal conductivity of the fan casing; and

h) cooling and removing the holding sectors and the inside heating belt.

[c2] A method according to claim 1, wherein the number of holding sectors is not less than three.

[c3] A method according to claim 1, wherein, during the thermal cycle, the temperature of the adhesive is monitored by means of at least one inside temperature probe placed inside the inside heating belt, the inside temperature probe being connected to means for measuring and

regulating temperature.

- [c4] A method according to claim 1, the fan casing including an outside wall, wherein at least one "outside" heating belt is placed against the outside wall in register with the abratable portion, the outside heating belt extending right around the fan casing and thus surrounding the abratable portion, said outside heating belt being connected to an electrical power supply and being heated during the thermal cycle.
- [c5] A method according to claim 4, wherein, during the thermal cycle, the temperature of adhesive is also controlled using at least one outside temperature probe disposed against the outside heating belt, the outside temperature probe being connected to the temperature measuring means.
- [c6] A method according to claim 1, wherein the sealing surface of the abratable portion is subsequently machined.
- [c7] A method according to claim 1, wherein the abratable portion is machined using a grinder attached to the shaft.